

Work Order ID 60917

Monday, July 26, 2010 3:32:10 PM



Page 1

Item ID: D3836-041

Accept



Setup

Stop

Start

Stop

Revision ID:

Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 7/26/2010 Start Qty: 2.00



Required Date: 8/3/2010 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

H

Date: 10-07-24

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr							
D3836	Rev A							

100



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1- cut D3836-1 and D3836-3 rib as per dwg D3836

2- remove identification markings

3- deburr

4- weld D3836-1 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836

5- weld D2327-3 spacer bushing as per dwg D3836
A/R ER316 S.S. Rod Batch: *M107213*

6- grind weld flush where indicated on dwg

130



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Quality Control

Memo

0.00

*2 Cpl 10-07-28**SAD 10-07-28**② PD 10-07-29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60917

Monday, July 26, 2010 3:32:10 PM



Page 2

Item ID: D3836-041

Accept



Setup Start



Stop



Revision ID:

Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 7/26/2010 Start Qty: 2.00



Required Date: 8/3/2010 Req'd Qty: 2.00



Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Run Stop



Sequence ID/
Work Center ID

140



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

8.06.129

(X2)

041

150



Packaging

Packaging

Identify as per dwg & Stock Location:

WA

0.00

SAD

16-07-29

Ppc 10.07.28

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10.07.29 H

Pro-729
(2)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, July 26, 2010 3:32:16 PM

Work Order ID: 60917

Parent Item: D3836-041

Parent Item Name: Rib Assembly (Basket Lid LH)



Start Date: 7/26/2010

Start Qty: 2.00

Required Date: 8/3/2010

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

8

7

6

5

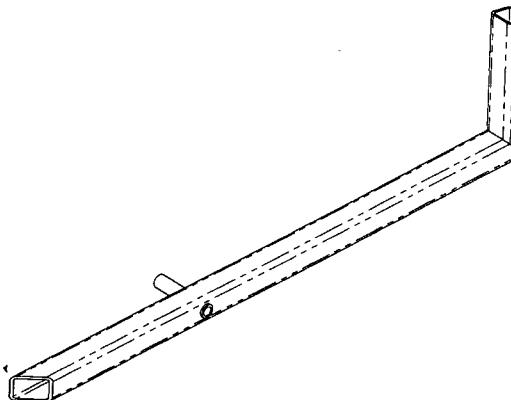
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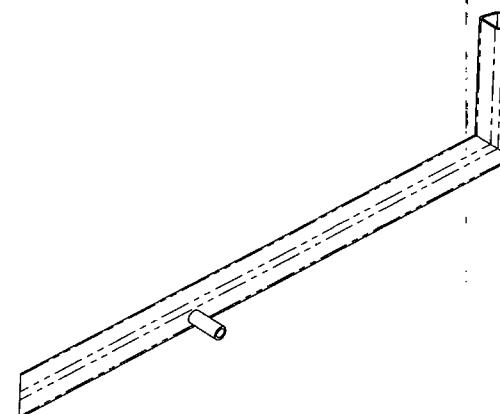
2

D

D



D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

B

C

A

B

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.99 lbs EACH
- 8) WELD PER DART QSI 004

8

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4

3

2

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO WORK ORDER
NO. 6097
D10-124

RELEASED
08/11/2011

A	NEW ISSUE	MB	08.09.24
REV.	BY	DATE	
DESIGN	<i>1</i>		
DRAWN	<i>1</i>		
CHECKED	<i>A-3</i>		
MFG. APPR.	<i>M</i>	REV. A	
APPROVED	<i>M</i>	SHEET 1 OF 3	
DE APPR.	<i>M</i>	SCALE	
DATE	08.09.24	NTS	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3836

TITLE: RIB ASSY (BASKET LID)

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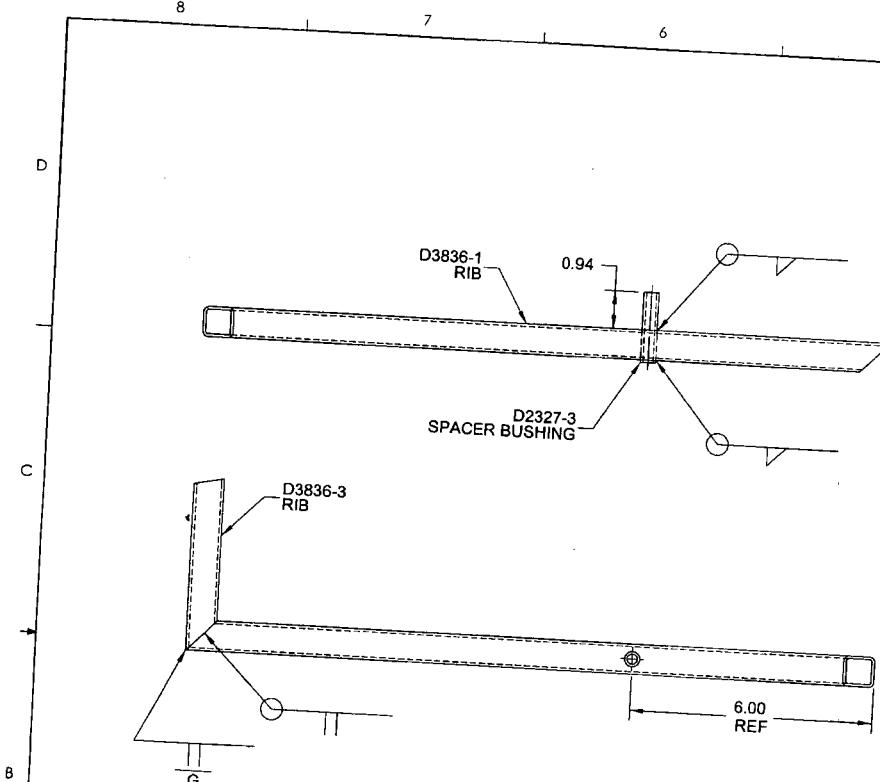
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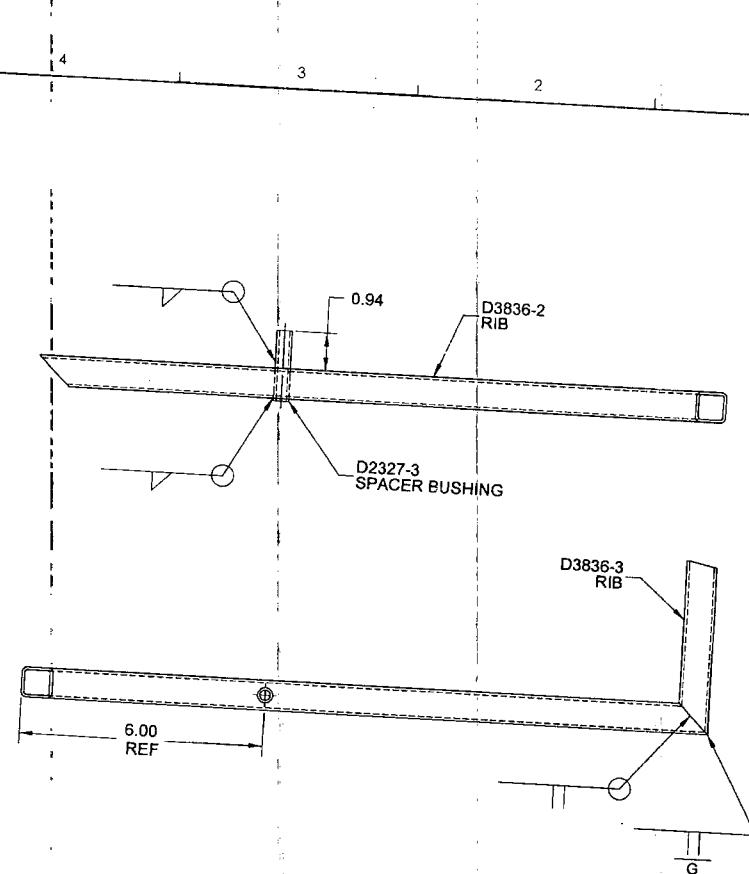
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3836-041 RIB ASSY (BASKET LID, LH)



D3836-042 RIB ASSY (BASKET LID, RH)

W0 6090
RELEASED
08/11/18 MTP

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
DATE	08.09.24	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS PROVIDED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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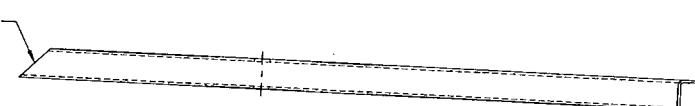
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8
1 7 1 6 1 5 1 4 1 3 1 2 1

0.75 X 45° CHAMFER



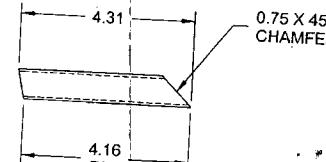
D3836-1 RIB

D
C
B
A

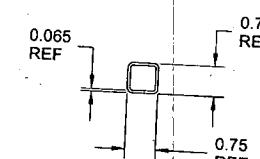
0.75 X 45° CHAMFER



D3836-2 RIB



D3836-3 RIB



TYPICAL SECTION VIEW

RELEASED
08/11/18

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D3836-2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

8

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2

DESIGN	<i>1</i>	DART AEROSPACE LTD	
DRAWN	<i>1</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ASS</i>	DRAWING NO.	D3836
MFG. APPR.	<i>1</i>	REV. A	
APPROVED	<i>1</i>	SHEET 3 OF 3	
DE APPR.	<i>1</i>	TITLE	RIB ASSY (BASKET LID)
DATE	08.09.24	SCALE	NTS

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